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**TITLE:** SUBMARINE OPTICAL CABLE  
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**INVENTOR-INFORMATION:**

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**ASSIGNEE-INFORMATION:**

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**INT-CL (IPC):** G02B006/44

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**ABSTRACT:**

**PURPOSE:** To increase interlayer adhesive strength, to improve the pressure-tightness of a submarine optical cable, and to eliminate the cause of a water run by performing the matte working of the external surface of a metallic tube which constrains a tensile strength wire and molding an insulator layer thereupon by extrusion.

**CONSTITUTION:** A metallic tape unwound from a metallic tape supply drum 15 is extended longitudinally along a cable wound with the high strength wire and formed into a cylinder gradually by a metallic tape forming roll 16. Then, the seam of the metallic tape is welded together by a next metallic tape welder 17 and the welded metallic tube 5 is formed almost round by a metallic tube forming roll 18 and passed through a drawing die 19 to increase its interlayer adhesive strength. A matte working roll 20 is pressed against the surface of the metallic tube 5 passed through the drawing die 19 among plural rolls 20a~20d to make its surface matte. The tube is wound temporarily around a take-up drum 21 and sent to an extrusion molding process where the next insulator layer is formed.

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